

Date: Wednesday, 28/01/2009 4:59:28 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 BEARPAW INSTALLATION KIT (48")
Job Number : 45313	
Estimate Number : 12283	
P.O. Number :	Part Number : D205564011
This Issue : 28/01/2009 S.O. No. :	Drawing Number : D2521
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : J
Previous Run : 44440	Material :
Written By :	Due Date : 10/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.01.29</u>	
Comment : Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC Est Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Handwritten: Cor JUD 09/02/18

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG008

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



Comment: MFG ENGINEERING
 Program Batch Number

Handwritten: 09.02.02

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 8.4000 sf(s)/Unit Total : 33.6000 sf(s) X2 66.

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"
 (MUHMWB10)

Batch:

Handwritten: 110520 X 2
 110721 X 10

Handwritten: B 9-2-18

Handwritten: 8

4.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

Cut Blank as per D2521 blank file

Handwritten: B 9-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:28 PM
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Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

J.L 09/02/12

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/02/12

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SS 09/02/13 (8)

8.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total : 14.8000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2182B055 Rubber Cushion

42737

SS 09/02/17 (4)

9.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
20 D2274 Radius Block

B4383E x45
B44547 x35

SS 09/02/17 (4)

10.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
20 D2529 Washer

42408

SS 09/02/17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

44049

SS 09/02/17 (x4)

12.0

D3544041

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

CLAMP

Batch:

44653

SS 09/02/17 (x4)

13.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch:

M110322429 M110865 x3

SS 09/02/17 (x4)

14.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A

Bolt

M110399

SS 09/02/17 (x4)

15.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416

Washer

M110523

SS 09/02/17 (x4)

16.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Batch:

M109282

SS 09/02/17 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

205-02-19 (4)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



(54)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

24 Rev C

9/2/18

sd

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

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DESIGN

DRAWN BY

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

D2521

SHEET 2 OF 3

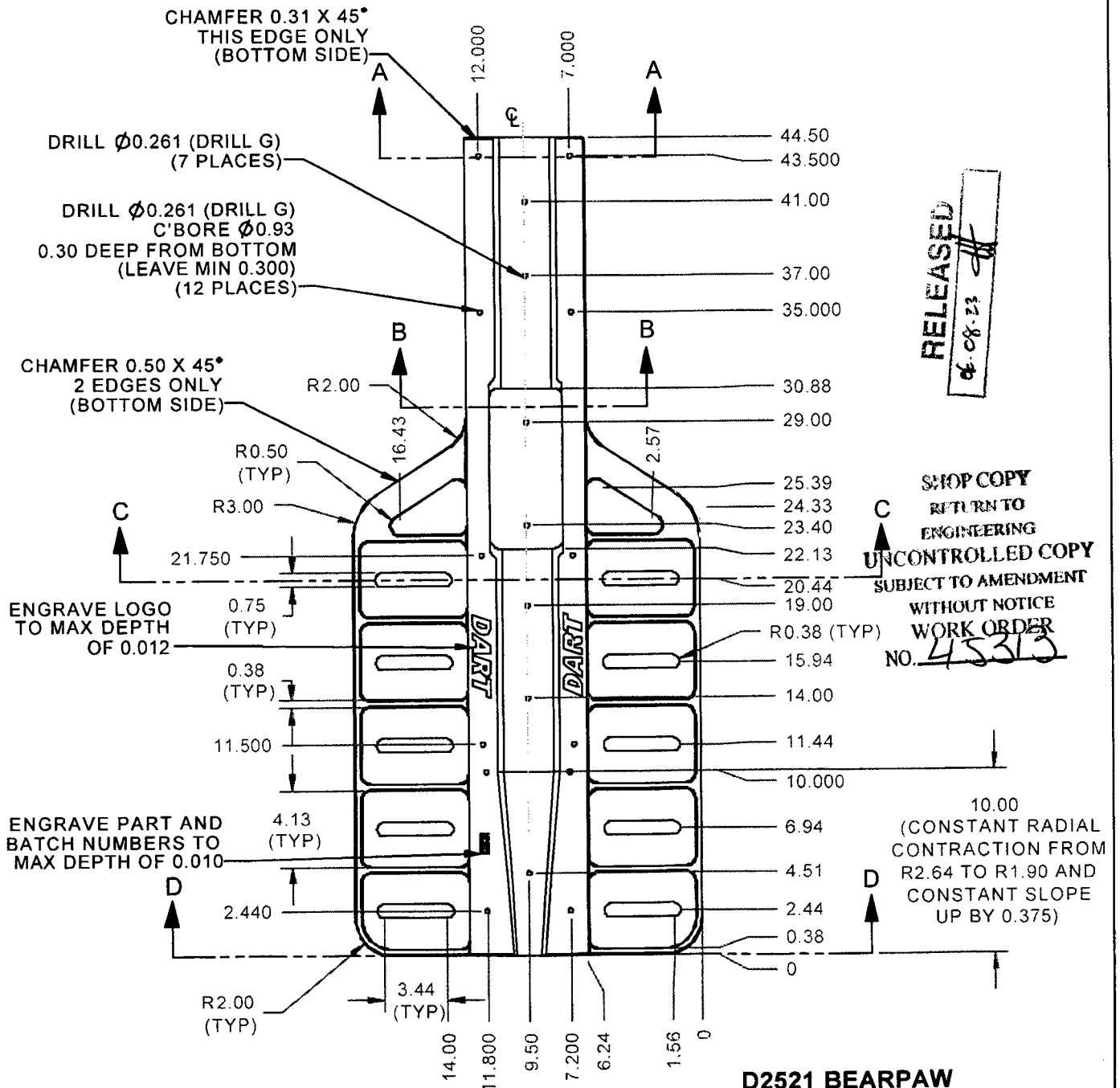
DATE

TITLE

SCALE

06.07.28**205 BEARPAW**

1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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REV. J

DATE

TITLE

SHEET 3 OF 3

SCALE

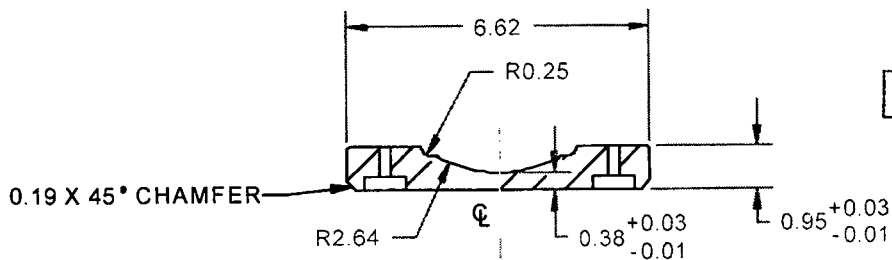
06.07.28

205 BEARPAW

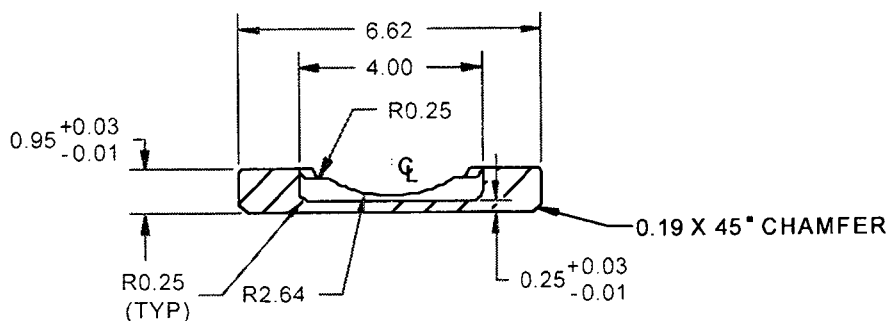
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RELEASED

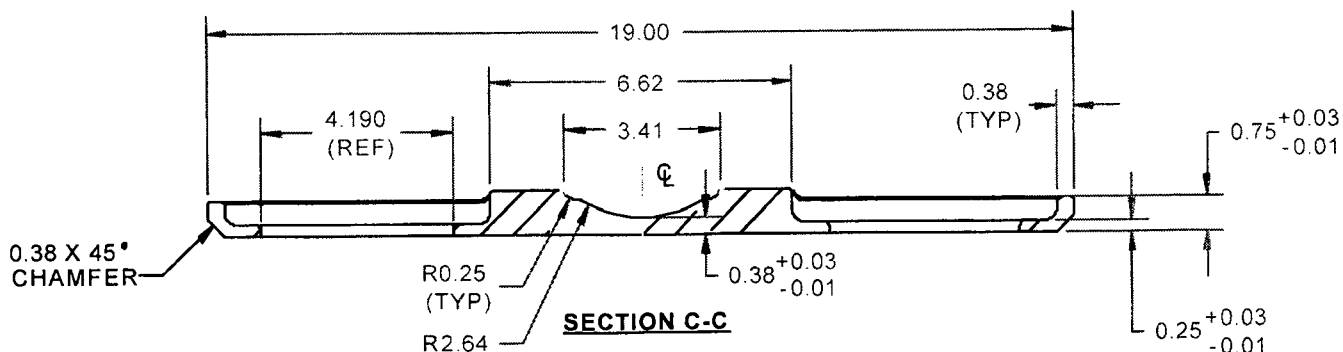
06.08.23



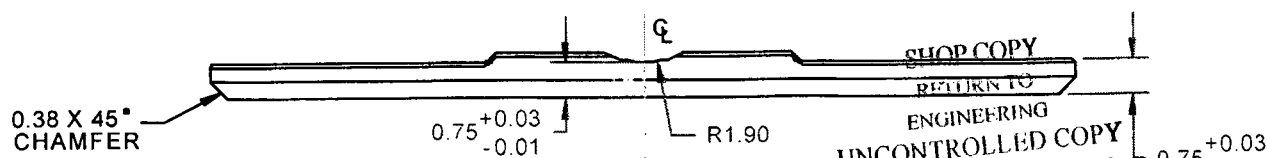
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

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